

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028966**Date Inspected:** 11-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** Andrew Keech**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS project**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and /or monitor American Bridge/Fluor (ABF) welding operations. This Quality Assurance (QA) Inspector, Craig Hager observed the following.

This QA Inspector was requested to attend a meeting at the ABF office at Pier # 7 this morning at 0700 hours. The scope of work, specific report details and general working conditions were discussed. The meeting ended at approximately 0800 and this QA Inspector proceeded to the jobsite at the tower base.

This QA Inspector randomly observed QC Inspector Andrew Keech performing Ultrasonic Testing (UT) for UT indications both parallel and transverse to the weld. The area of inspection was the Electro Slag Weld (ESW) on the shear plates, weld joint "W", face A, 120° Tee Joint configuration. Ultrasonic testing was performed from Y-6750 to Y-9780.

This QA Inspector performed a verification UT of the same area and within this area a total of 3 indications were observed; all transverse.

This QA Inspector compared the UT data obtained with that obtained by QC Inspector Andrew Keech; the results were basically the same.

The UT performed was with a 70 degree shearwave transducer. For specific details see Ultrasonic Testing Report

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

(TL-6027) this date.

This QA Inspector did not observe welding being performed this date.

Summary of Conversations:

This QA Inspector had general conversations with American Bridge/Fluor (ABF) personnel, QC personnel and Caltrans personnel during the shift. Except as described above there were no notable conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 674-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer
